

Work Order ID 102533

Wednesday, May 29, 2013 12:46:08 PM

102533

Page 1

Item ID: D3687-1

Revision ID:

Item Name: Mount

Start Date: 5/29/2013 Start Qty: 7.00

Required Date: 6/28/2013 Req'd Qty: 7.00

Reference:

Approvals:

Process Plan:

QC:

Date: 5/29/2013 Tooling:

Date: SPC (Y/N):

N9000040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Run Start *NR1*

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

Draw Nbr

Revision Nbr

D3687

Rev D

105

0.00

105

Outsource

Outsource process - Machining

Memo

Issue P/O:

Machine as per Dwg D3687

Possible Supplier: Globus Precision

Conformity sheet required

0.00

110

Receive & Inspect for Damage & Mat'l Certs

0.00

110

Packaging

Packaging

Memo

Ensure certificate of conformity is attached

0.00

120

QC6- Inspect dimensions to drawing

0.00

120

QC

Quality Control

Memo

INSPECT HOLE ALIGNMENT USING DT9707 JIG

0.00

DAS
27
9-89

11/17

CL 13/05/13 (8)

2013/11/13 (8)

P/O

7

Work Order ID 102533

Wednesday, May 29, 2013 12:46:08 PM

102533

Page 2

Item ID: D3687-1

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Mount

Start Date: 5/29/2013 Start Qty: 7.00

7

Cust Item ID:

Required Date: 6/28/2013 Req'd Qty: 7.00

7

Customer:

References:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

124

0.00

124

Purchasing

Memo

0.00

Purchasing

Issue P/O FOR LIQUID PENETRATION
P/O #: 210. 22586

Certificate of conformity is required

CL 14/01/15 @

125

Receive & Inspect for Damage & Mat'l Certs

0.00

125

Packaging

Memo

0.00

Packaging

ENSURE NDT RESULT IS ATTACH

14/01/15 @

127

QC6- Inspect dimensions to drawing

0.00

127

QC

Memo

0.00

Quality Control

DIMENSIONAL CHECK,
ENSURE THAT BOLT HOLES ARE CORRECT SIZE

1

14.01.15

Work Order ID 102533

Wednesday, May 29, 2013 12:46:08 PM

102533

Page 3

Item ID: D3687-1

Revision ID:

Item Name: Mount

Start Date: 5/29/2013 Start Qty: 7.00

Required Date: 6/28/2013 Req'd Qty: 7.00

Reference:

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

7

7

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

Identify as per dwg & Stock Location: GA

0.00

130

Packaging

Memo

0.00

Packaging

1X

DAS
28
9-89

14-01-15

140

QC 21- Final Inspection - Work Order Release

0.00

140

QC

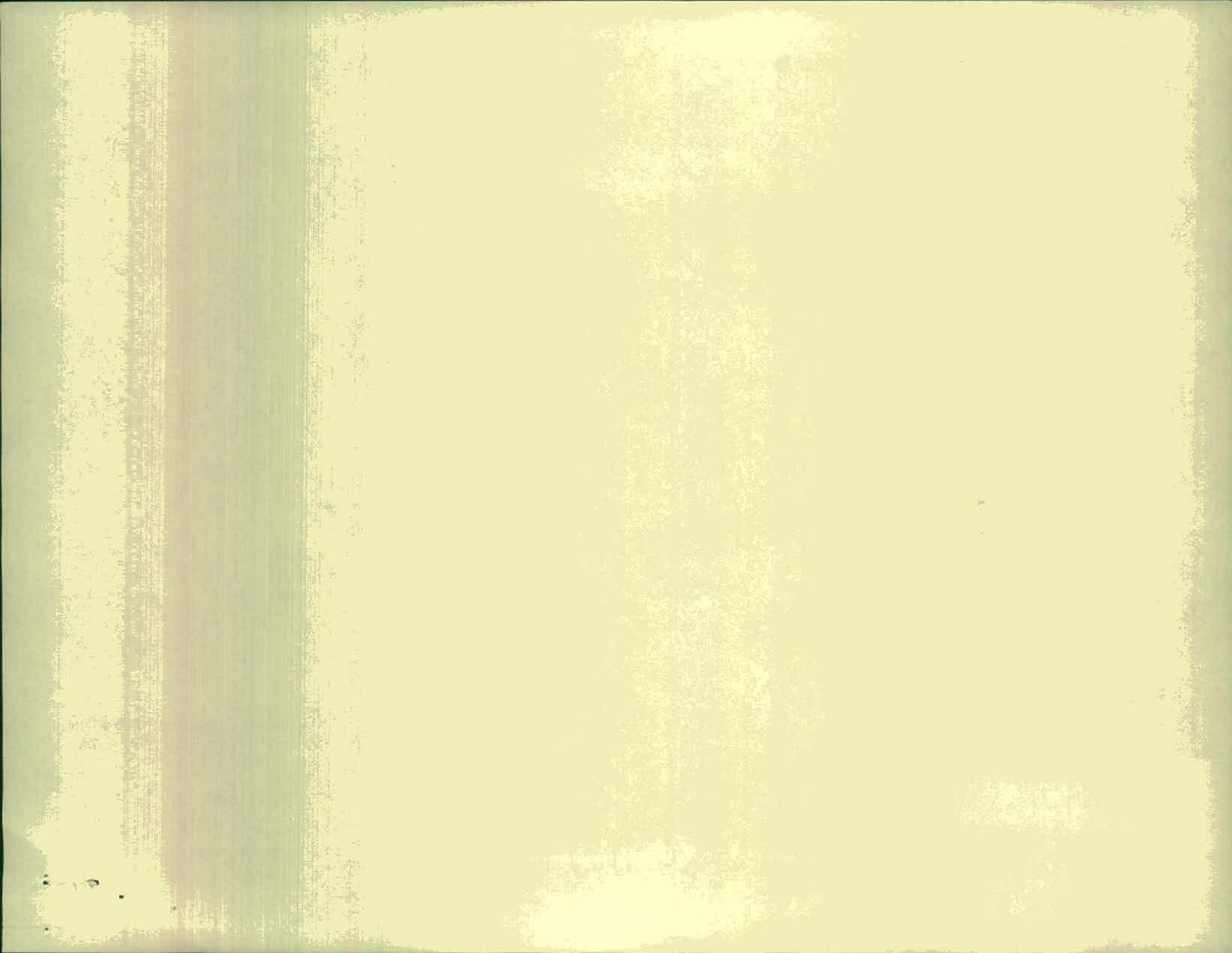
Memo

0.00

Quality Control

14-01-15

14-01-15



Picklist Print

Monday, December 02, 2013 1:32:00 PM

Page 1

Work Order ID: 102533

Parent Item: D3687-1

Parent Item Name: Mount

Start Date: 5/29/2013

Required Date: 6/28/2013

Start Qty: 7.00

Required Qty: 7.00

Comments: IPP Rev:A New Issue 08-01-15 JLM Verified By:EC
 IPP Rev:B Added Contion H-900 JLM Verified By:DD IPP REV C: ADDED QC6
 10.09.09 JLM VERIFIED BY DD
 IPP REV D:ADDED DT9707 INSPECTION JIG 11-01-05 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M174PH- H900B3.937X4.750 17-4SS Bar H900-3.937x4.750		Purchased	No					9.6667		2.33331			

CX 13/05/29

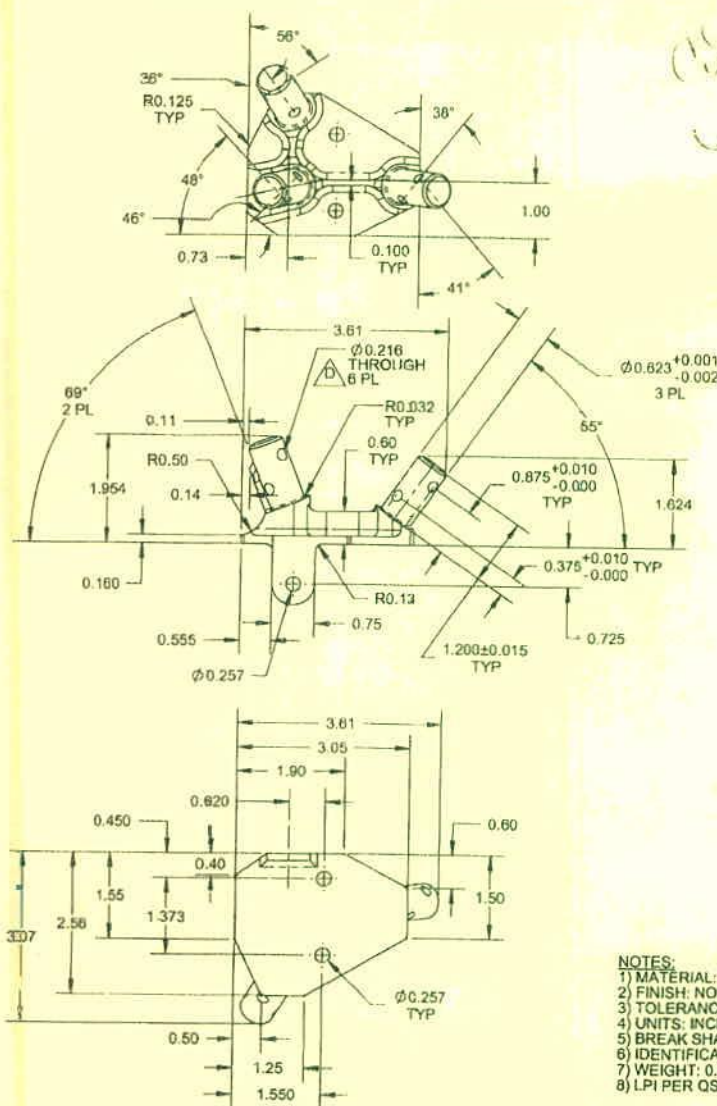
Location	Loc Qty	Loc Code
MAT049	9.66669	
m126220	4	
m126352	5.66669	

D3687-1P Mount	Purchased	No				105	Each	0.0000				
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2.66669

78

13/11/36



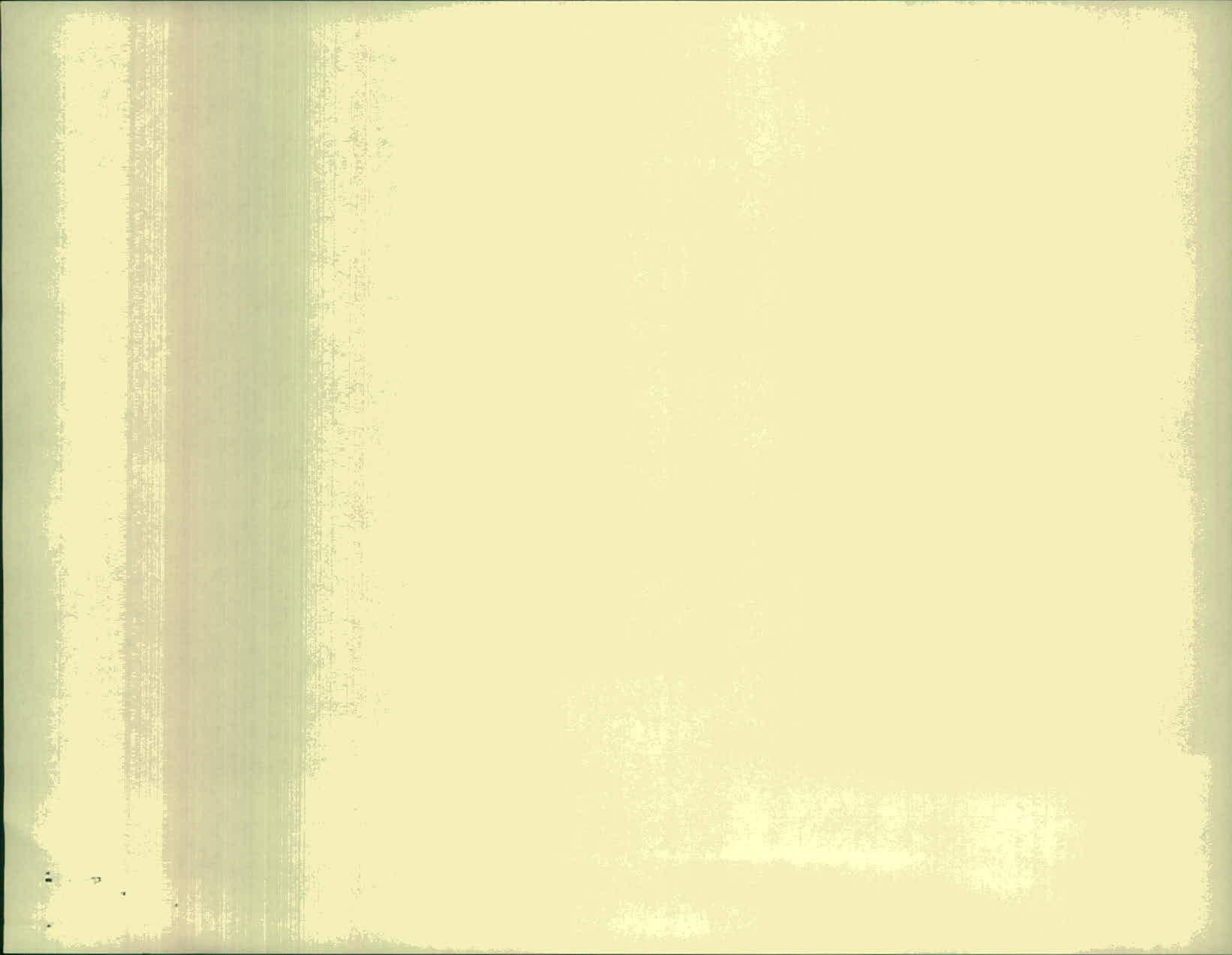
D3687-1 MOUNT

- NOTES:
- 1) MATERIAL: 17-4PH SS BAR PER AMS 5843, H-900 CONDITION
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.81 lb
 - 8) LPI PER QSI 038 4.1.1 (ASTM E1417 LEVEL 2)

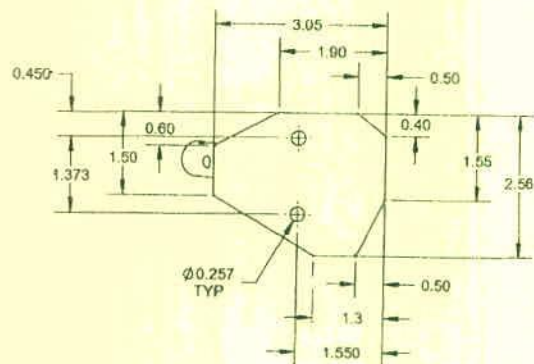
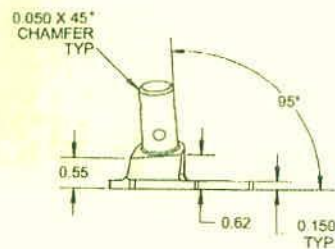
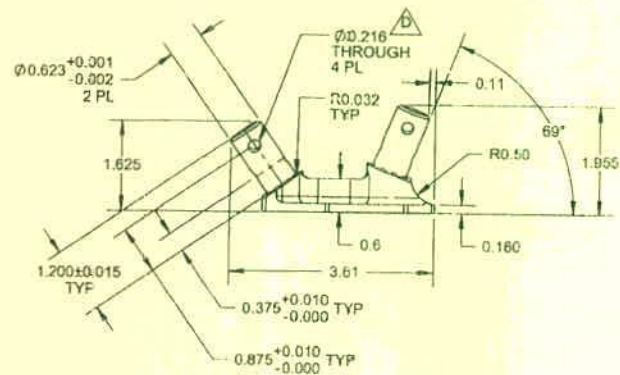
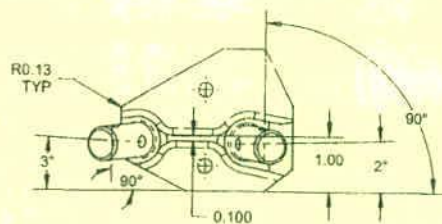


RELEASE
2013-01-22
W10

D	PILOT HOLE Ø0.216 WAS Ø0.189 (ZN C7-1, C8-2). REF NCR12.2074	DB	12.12.05
C	0.555 WAS 0.50 (ZN B6-1); 1.373 WAS 1.375 (ZN A8-1, A8-2); ADD 0.620 (ZN B7-1) PER NCR09-084. UPDATE NOTE 8 TO REF QSI (ZN A6-1, B3-2); Ø0.257 WAS Ø0.250 (ZN A6-1, B7-1, B7-2)	RF	09.08.28
B	CHANGE TO 17-4PH H-900 (ZN A6-1 & B3-2); R0.032 WAS R0.015 (ZN C7-1 & C7-2); REFORMATTED TO CURRENT DWG STANDARDS	RF	08.11.24
A	NEW ISSUE	RF	08.03.12
REV	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DB		
CHECKED	MB	DRAWING NO.	REV. D
MFG. APPR.	JLM	D3687	SHEET 1 OF 2
APPROVED	W10	TITLE	SCALE
DE APPR.	W10	MOUNT	NTS
DATE	12.12.05	<small> COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS UNCLASSIFIED AND IS AVAILABLE FOR REPRODUCTION BY ANY PERSON OR ORGANIZATION WITHOUT PERMISSION FROM DART AEROSPACE LTD </small>	



8 7 6 5 4 3 2 1



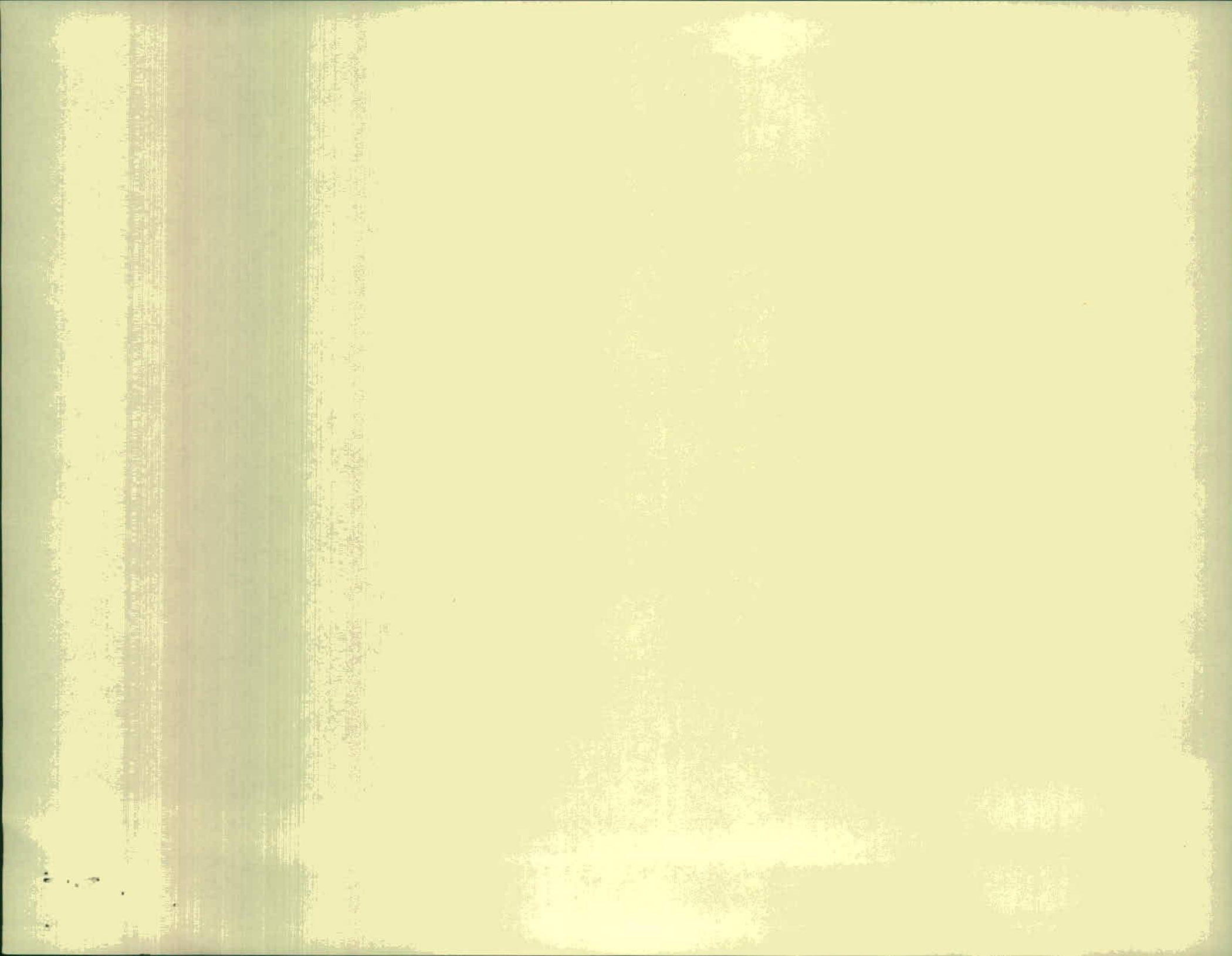
D3687-3 MOUNT

- NOTES:
 1) MATERIAL: 17-4PH SS BAR PER AMS 5643, H-900 CONDITION
 2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: NONE
 7) WEIGHT: 0.64 lb
 8) LPI PER QSI 038 4.1.1 (ASTM E1417 LEVEL 2)

RELEASED
 2013-01-22
 MD

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	DB	HAWKESSBURY, ONTARIO, CANADA	
CHECKED	MB	DRAWING NO.	REV. D
MFG. APPR.	JLM	D3687	SHEET 2 OF 2
APPROVED	MD	TITLE	SCALE
DE APPR.	MD	MOUNT	NTS
DATE	12.12.05	<small>COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PROPRIETARY AND CONFIDENTIAL. IT IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR DISCLOSED OR COMMUNICATED TO ANY OTHER PERSON OR ENTITY WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.</small>	

8 7 6 5 4 3 2 1





Ottawa, Ontario
K1B 4S6

Phone # 613-899-2405

Packing Slip

Date	Invoice #
11/26/2013	759

Ship To

Main Finished Goods Location
Dart Aerospace
1270 Aberdeen Street
Hawksbury, Ontario
K6A 1K7

P.O. No.	Ship	Via	FOB	Project
19864	11/26/2013	Federal Express	Archer	

Qty	Item Code	Description
8	Sales	D3687-1P HST (ON) on sales



2228 Gladwin Cres.
Ottawa, Ont.
K1B 4S6

Telephone (613) 899-2405
Fax (613) 226-1719

Certificate of Compliance

To:
Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury Ont.
K6A 1K7

26 November 2013

Po Number	Part Number	Quantities
19864	D3687-1P	8

It is hereby certified that all articles mentioned above are in conformance with the requirements, specification and drawings as listed on customer purchase order number, 19864 issued by Dart Aerospace Inc.

Greg Kumpula
Quality Inspector
Archer Precision Inc.
2228 Gladwin Cress.
Ottawa, Ontario
K1B 4S6

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>															
Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>															
Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>															
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence
		<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge
		<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other

Chantal Lavoie

From: Alex Mazerolle <alex@archerprecision.ca>
Sent: Friday, December 06, 2013 9:17 AM
To: Chantal Lavoie
Subject: RE: po19864

Hi Chris

Please send via our FedEx account 377329899.

Alex Mazerolle



President

Tel: 613-226-1579

Fax: 613-226-1719

From: Chantal Lavoie [<mailto:clavoie@dartaero.com>]
Sent: Friday, December 06, 2013 9:14 AM
To: Alex Mazerolle <alex@archerprecision.ca> (alex@archerprecision.ca)
Subject: po19864

Hi Alex,

We have rec'd on po19864 part D3687-1. We would need to send one back for a re-work, there a hole that is not completed.

Thanks
Chantal

Ref: PO19864
Dep:

Date: 06Dec13
Wgt: 2.00 LBS

DV:

SVC: PRIORITY OVERNIGHT
TACK 5612 9602 5961

SHIPPING:
SPECIAL:
HANDLING:
TOTAL:

0.00
0.00
0.00
0.00



Work Order Traveler

Sky Service F.B.O. Inc.

DOT-APP-53-89 / EASA 145.7142 / BDA | AMO | 385

WO #: YUL 80057

Customer: DART AEROSPACE

Cust Ref #: 22506





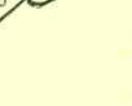
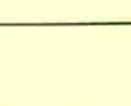
A/C Make:
TSN:Model:
CSN:Reg:
TSO:S/N:
CSO:

Task:

Sequence:

Work Required: CARRY OUT LIQUID PENETRANT INSPECTION ON FOLLOWING ITEMS:

- ① WO ID 107718 ITEM-D212-664-101 FWD CROSSTUBE HIGH
- ② WO ID 109876 ITEM-D212-664-107 FWD CROSSTUBE LOW
- ③ WO ID 110536 ITEM-D212-664-101 FWD CROSSTUBE HIGH
- ④ WO ID 109606 ITEM-D212-664-107 FWD CROSSTUBE LOW
- ⑤ WO ID 102533 ITEM-D3657-1 MOUNT QTY 1
- ⑥ WO ID 110243 ITEM-D3011-1 RAPPEL QTY 6

Action Taken/Findings/Discrepancies	Date	Name/License/Sign
LIQUID PENETRANT CARRIED OUT ON FOLLOWING ITEMS		GARY SMITH
① WO 107718 - NO CRACKS FOUND	14/1/14	
② WO 109876 - NO CRACKS FOUND	14/1/14	
③ WO 110536 - NO CRACKS FOUND	14/1/14	
④ WO 109606 - NO CRACKS FOUND	14/1/14	
⑤ WO 102533 - NO CRACKS FOUND	14/1/14	
⑥ WO 110243 - NO CRACKS FOUND	14/1/14	
PENETRANT - ARBUX 970PZSE BATCH # TPO10484 BL # M20189		

I certify that the maintenance described above has been performed
in accordance with the applicable std of airworthiness.

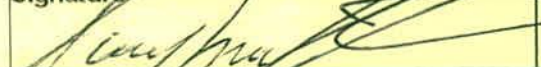
Signature

ACA/SCA

Date

Documentation Used

Rev - Date

14 JAN
2014

ASTM 1417 REV 13

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